

Work Order ID 103083

103083

Page 1

June-12-13 9:26:40 AM

646.3312

Item ID: 646.3312

103083

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Center Plate

Start Date: 6/11/13

Start Qty: 10.00 *10*

Required Date: 6/11/13

Req'd Qty: 10.00 *10*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 13/07/07 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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646.3300	N/C	0.00							
----------	-----	------	--	--	--	--	--	--	--

100									
-----	--	--	--	--	--	--	--	--	--

100	BAND SAW	0.00	DAS	44	9-8	13/07/07	16	0	
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Bandsaw	Memo	0.00							
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Jeaspa Bandsaw	Cut Blank at 16.300"								
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*** ONE BLANK MAKES TWO PARTS***

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110	HAAS CNC VERTICAL MACHINING #1	0.00	DAS	44	9-8	13/07/07	16	0	
-------	--------------------------------	------	-----	----	-----	----------	----	---	--

HAAS 1	Memo	0.00							
--------	------	------	--	--	--	--	--	--	--

HAAS CNC vertical machine #1	1-Machine per folio FB153								
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DWG REV: ~~100~~ N14

FOLIO REV: ~~100~~ A4

2- deburr and break all sharp edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		Other <input type="checkbox"/>
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Work Order ID 103083

103083

Page 2

June-12-13 9:26:40 AM

Item ID: 646.3312

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Center Plate

Start Date: 6/11/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

(DAS)
44
9-3

13/07/07

16 0

120

QC

Quality Control

130

QC8- Inspect parts - second check

0.00

13/07/08

16 0

130

QC

Quality Control

131

131

HandFinish

Hand Finishing

0.00

0.00

Memo

CLEAN AND REMOVE ALL PART MARKING

16 13-7-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Work Order ID 103083***103083***

Page 3

June-12-13 9:26:40 AM

Item ID: 646.3312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Center Plate

Stop

NS2

Start Date: 6/11/13

Start Qty: 10.00

10

Required Date: 6/11/13

Req'd Qty: 10.00

10

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

140

Outsource4

Outsource process - Anodize

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Memo

Issue P/O to ATG : 20560

1- Black Anodize as per Dwg 646.3300

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

150

150

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

155

155

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

CD 13/07/12 (16)P/13/07/1 (16)(16) 13.08.06 10

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		<input type="checkbox"/> Other		

Picklist Print

June-12-13 9:26:40 AM

Page 1

Work Order ID: 103083

Parent Item: 646.3312

Parent Item Name: Center Plate

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12/11/16 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M17075T6B5.000X0.375 7075-T6 BAR 5.000" X 0.375"		Purchased	No			100	f	46.8260	0.68	7.157895			

Location	Loc Qty	Loc Code
MAT049	46.826	
123218	44.362	
123418	2.464	

11 44 04 13/07/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced							
	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up							
	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure							
	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld							
	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled							
	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other							
	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge								
	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread									
	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set									
	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration									
	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence									

DART AEROSPACE LTD

Work Order:

103073

Description: Center PLATE

Part Number:

641a.3310

Inspection Dwg: 641a.3300 Rev: N/C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.538	+/- .005	10.538	✓		31006	Vern -
10.093	+/- .002	10.093	✓		31006	Vern -
8.815	+/- .002	8.815	✓		"	"
8.221	+/- .002	8.221	✓		"	"
6.815	+/- .002	6.815	✓		"	"
4.752	+/- .002	4.752	✓		FK-04	Vern -
4.159	+/- .002	4.159	✓		"	"
2.690	+/- .002	2.690	✓		"	"
2.471	+/- .002	2.471	✓		"	"
.690	+/- .002	.690	✓		"	"
.313	+/- .002	.313	✓		"	"
1.000	+/- .002	1.000	✓		"	"
1.250	+/- .002	1.250	✓		"	"
1.410	+/- .002	1.410	✓		"	"
2.156	+/- .002	2.156	✓		"	"
.174	+/- .002	.177	✓		"	"
.209	+/- .002	.209	✓		"	"
R.125	+/- .005	.125	✓		R-G	
R.295	+/- .005	.295	✓		R-G	
3.800	3.755 +/- .005	3.799	✓		FK-04	Vern -
.375	+/- .005	.373	✓		"	"

DAS

44

0.80

Measured by:	44
Date:	13/07/07

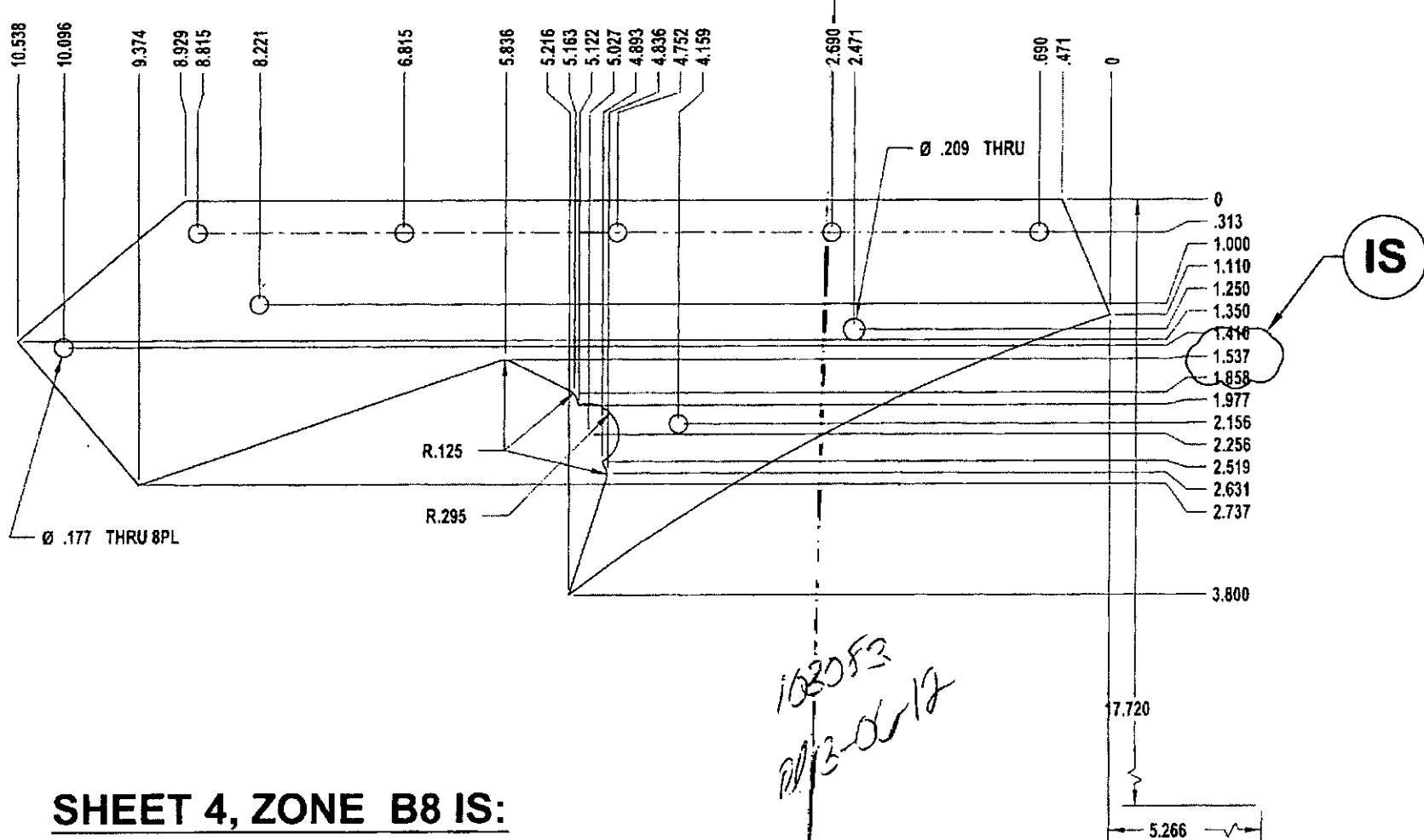
Audited by:	and
Date:	13/07/08

Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03724				SHEET 1 OF 1		
	DWG NO. 646.3300		REV: N/C	PREPARED BY I.B. PETERS	DATE: 12/05/12		EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: UPPER CUTTER ASSY						
	APPROVED BY:	ENGR: <i>[Signature]</i>	MFG: <i>[Signature]</i>	QC: <i>[Signature]</i>	FFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED ORDINATE DIMENSION.			ECR: D-12-025		

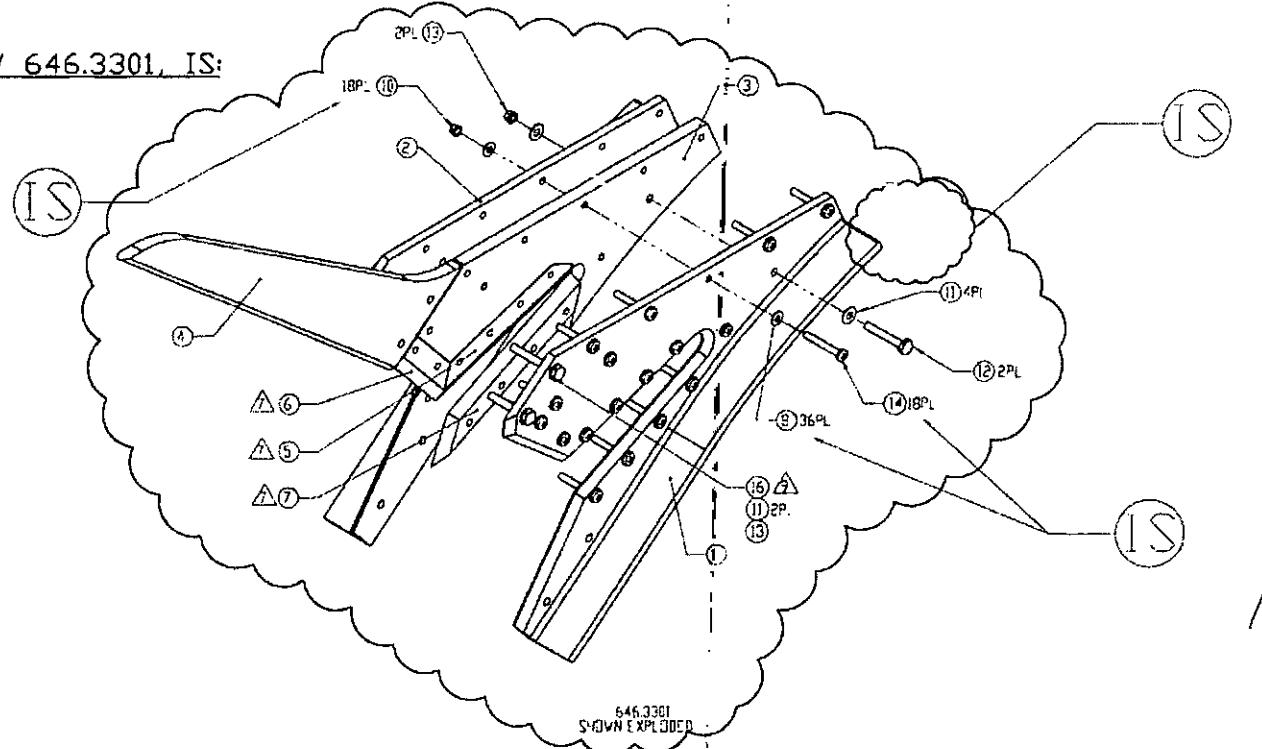


SHEET 4, ZONE B8 IS:

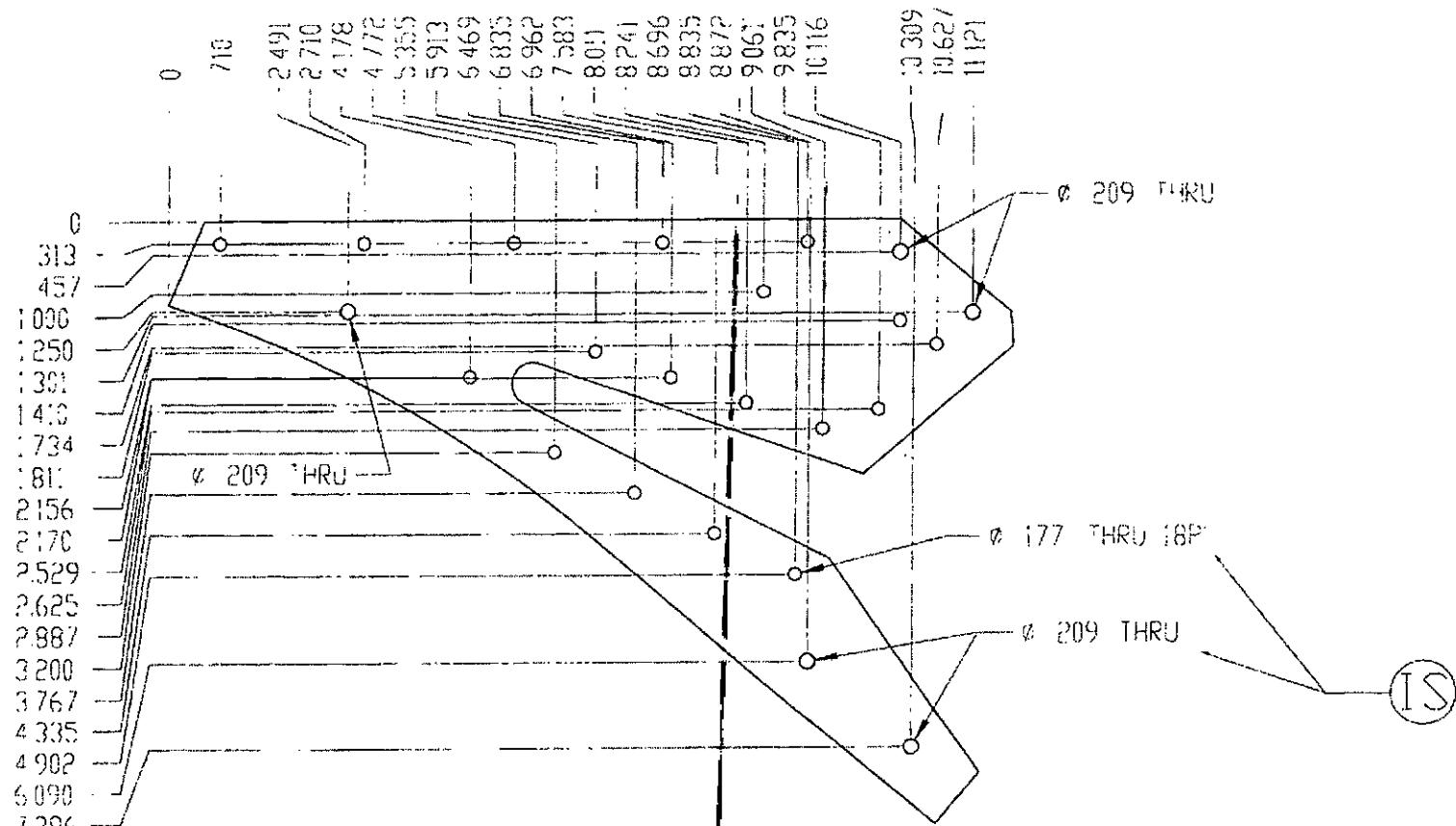
DOCUMENTS EFFECTED:	<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196			SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
DWG TITLE: UPPER CUTTER ASSY					
APPROVED BY: ENGR <i>P. Brown</i>	MFG <i>de la Torre</i>	QC <i>SST</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS					

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			.3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	
<input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM				<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	
				DER REVIEW REQUIRED	
				<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

SHEET 3, SECTION VIEW A-A, IS:

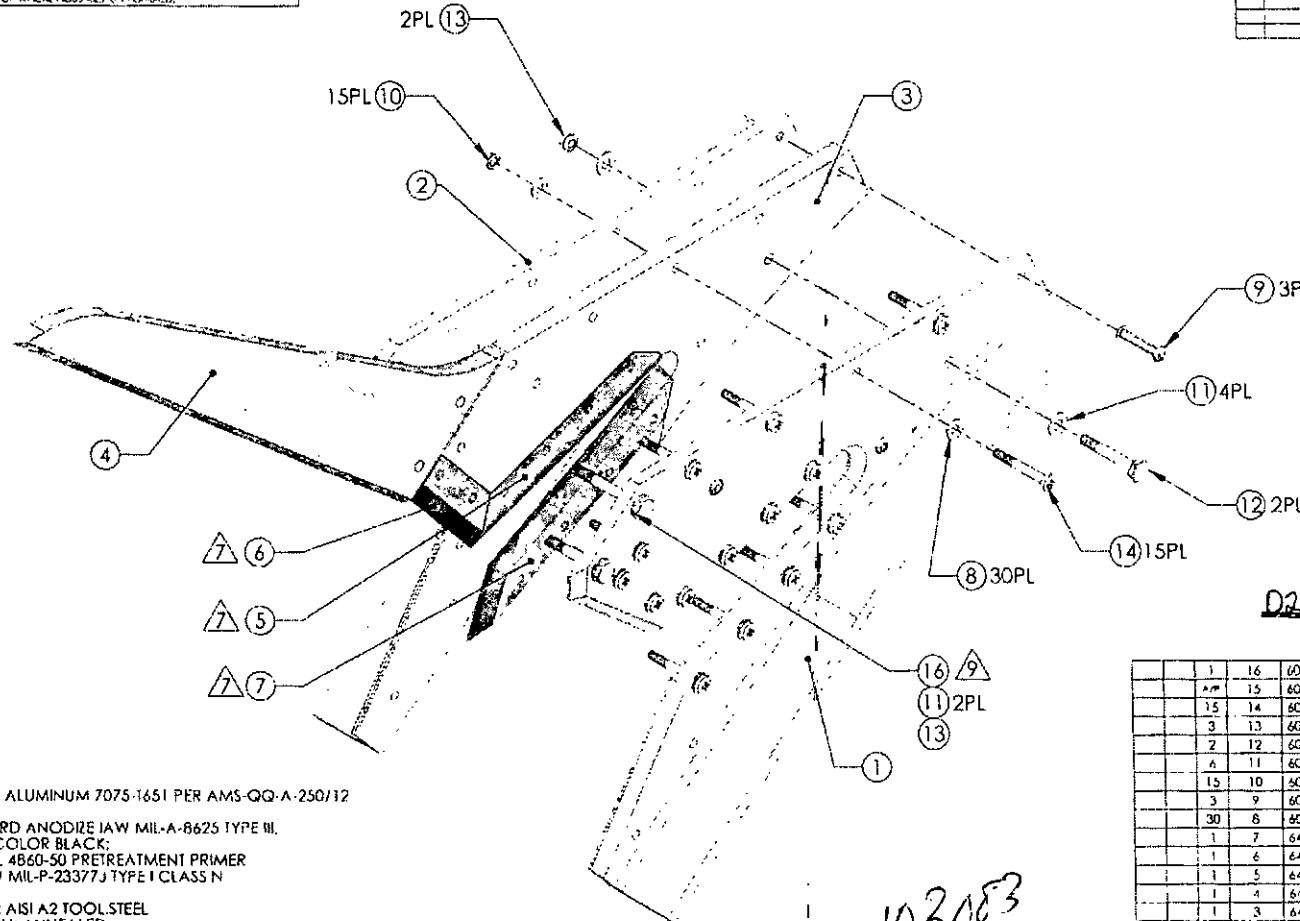
16303

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16

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REV	DESCRIPTION	DATE	DRAWN BY



NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4B60-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL CONDITION: ANNEALED POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
- 5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6. IDENTIFY IAW MPP-120
- 7. APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
- 8. CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9. INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

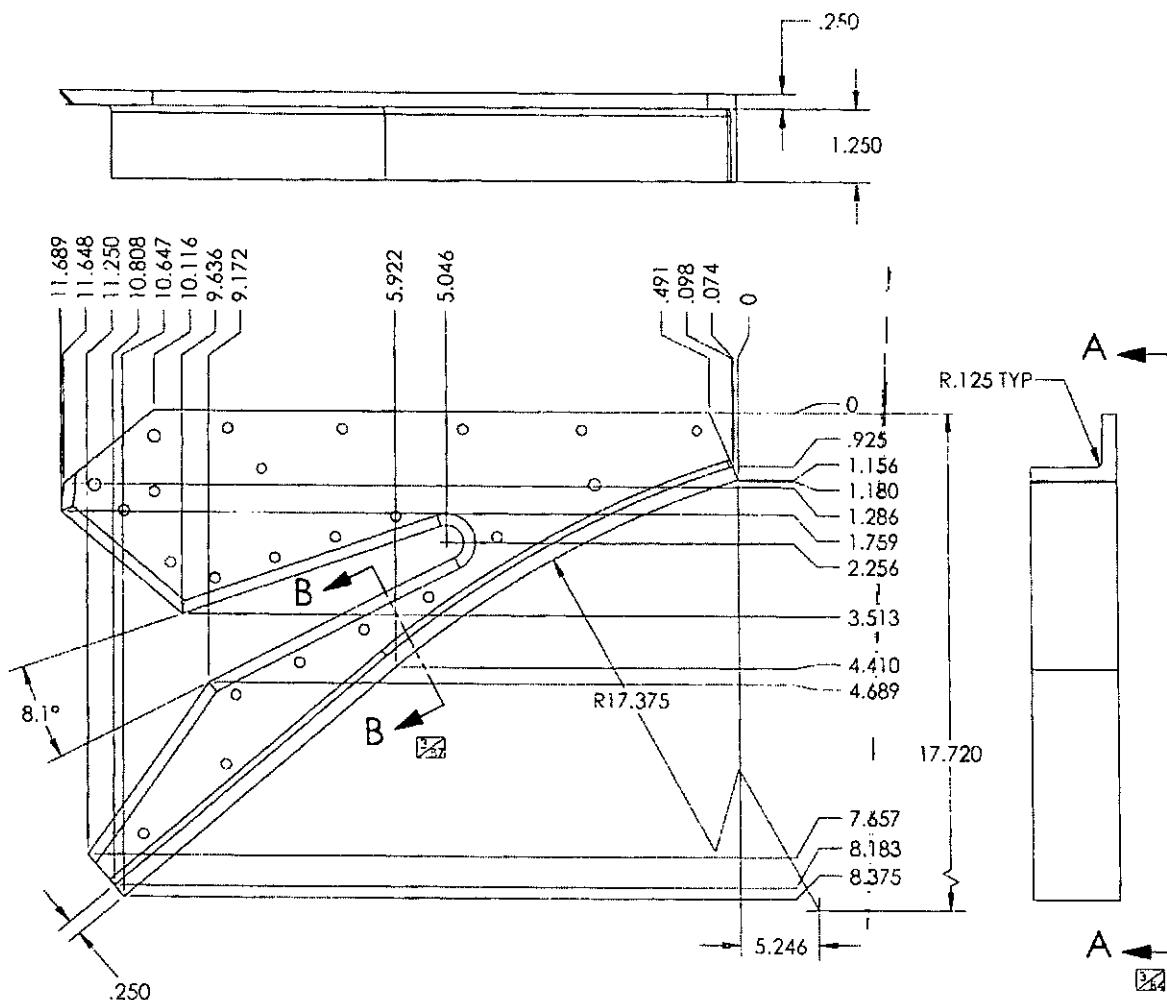
UNINCORPORATED ECN(S)

D21946, D3724

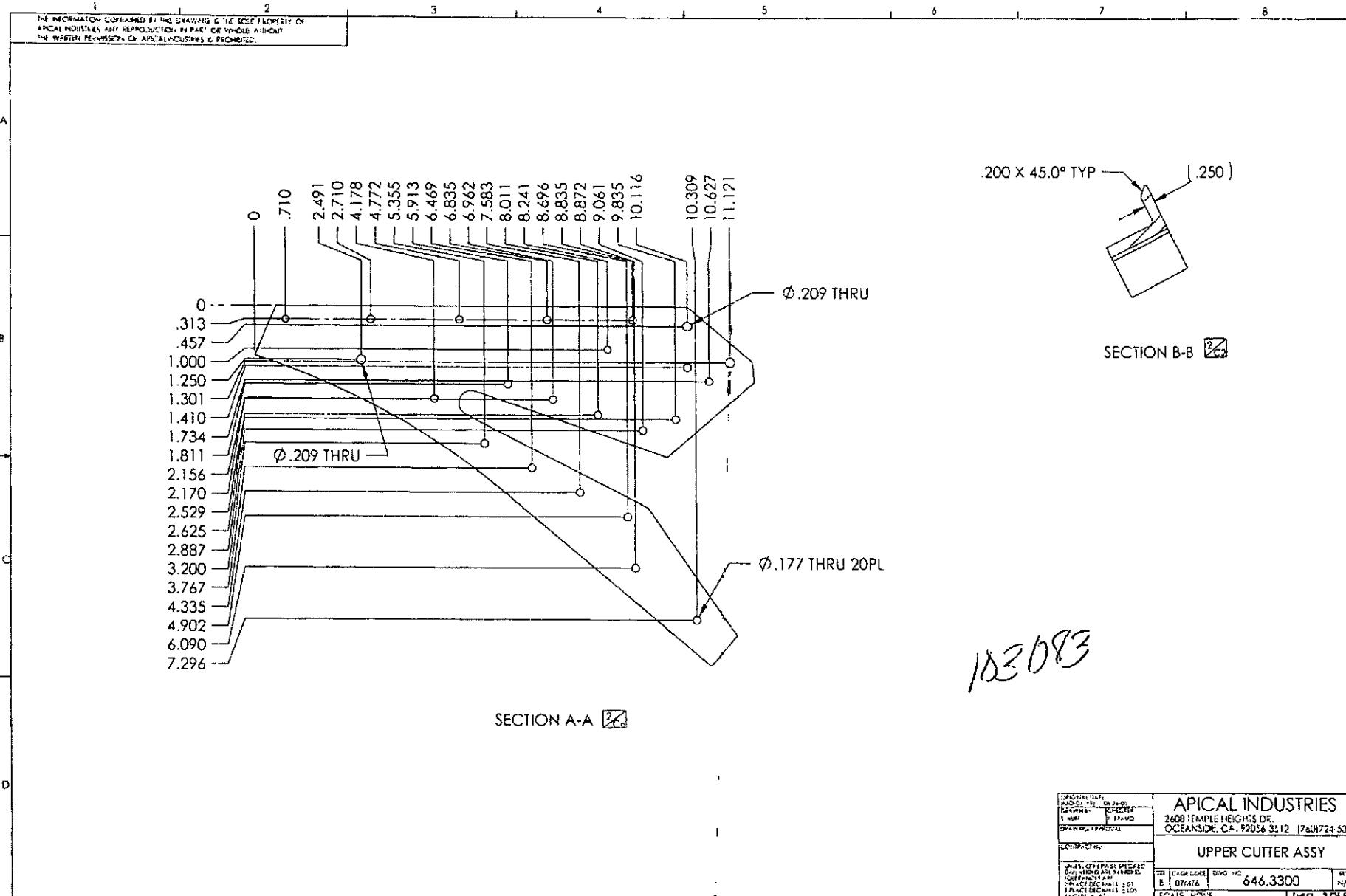
QTY	HND #	PART #	DESCRIPTION	MATL	SPEC.
			PARTS LIST		
1	16	601.2834	BOLT	AMS 1104	
1	15	601.2045	RTV, LOCTITE 598		
1	14	601.2765	SCREW	AMS2709-04019	
1	13	601.1624	LOCKNUT	AMS 4423	
2	12	601.2763	BOLT	AMS 1104	
4	11	601.1627	WASHER	AMS 110207P	
1	10	601.1541	LOCKNUT	AMS 4423	
3	9	601.2766	RIVET	AMS2709-04018	
30	8	601.2764	WASHER	AMS 110207P	
1	7	646.3316	BLADE		
1	6	646.3315	BLADE		
1	5	646.3314	BLADE		
1	4	646.3313	UPPER GUIDE		
1	3	646.3312	CENTER PLATE		
1	2	646.3311	RH HALF		
1	1	646.3310	LH HALF		
		646.3301	UPPER CUTTER ASSY		
			REVISIONS		
			NEXT ASSY IS		
			646.4000		
			DRAWN BY		
			APICAL INDUSTRIES		
			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			83		
			APPROVED		
			DATE		
			646.3300		
			REV		
			NYC		
			SCALE		
			NONE		
			SHEET		
			1 OF B		

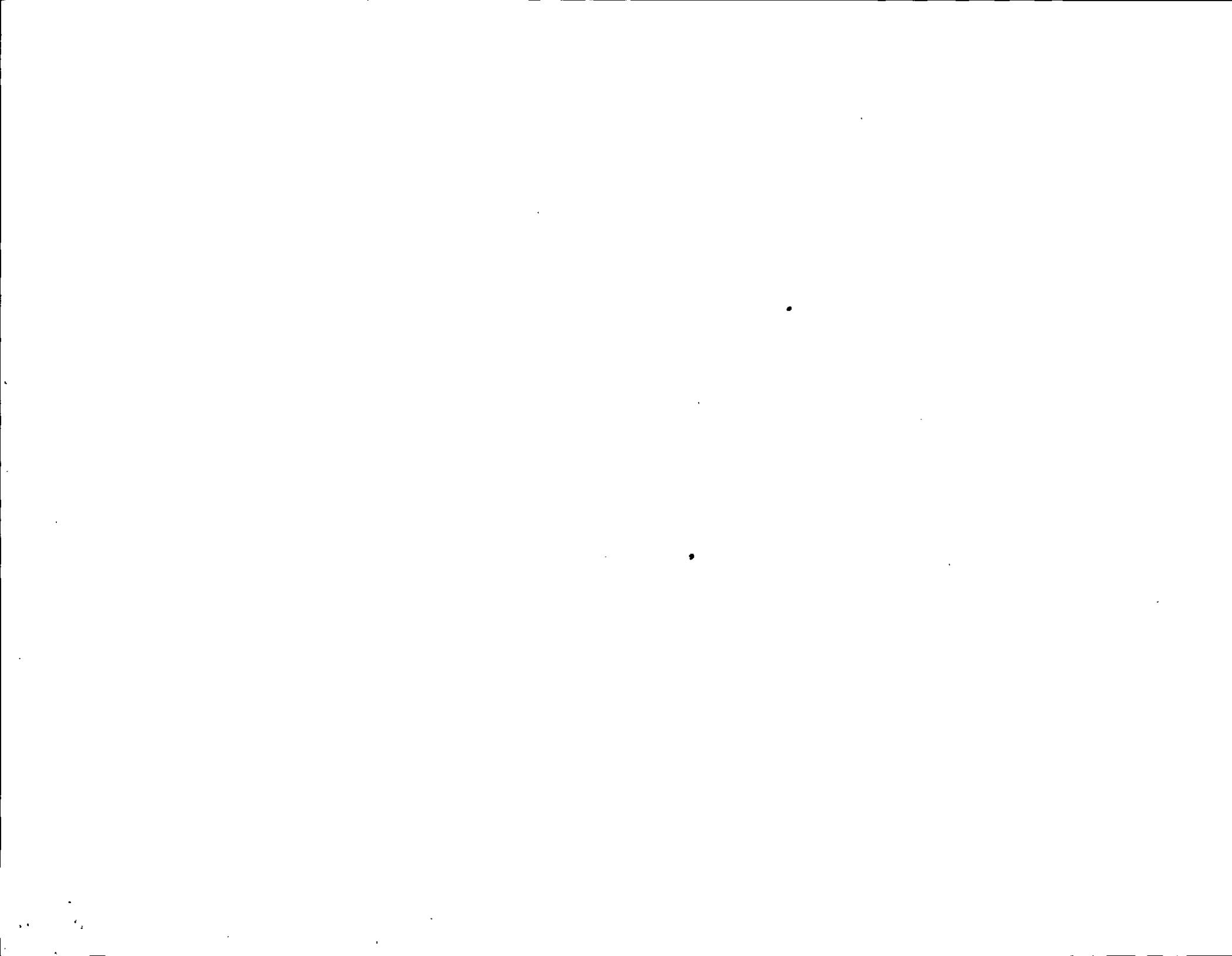
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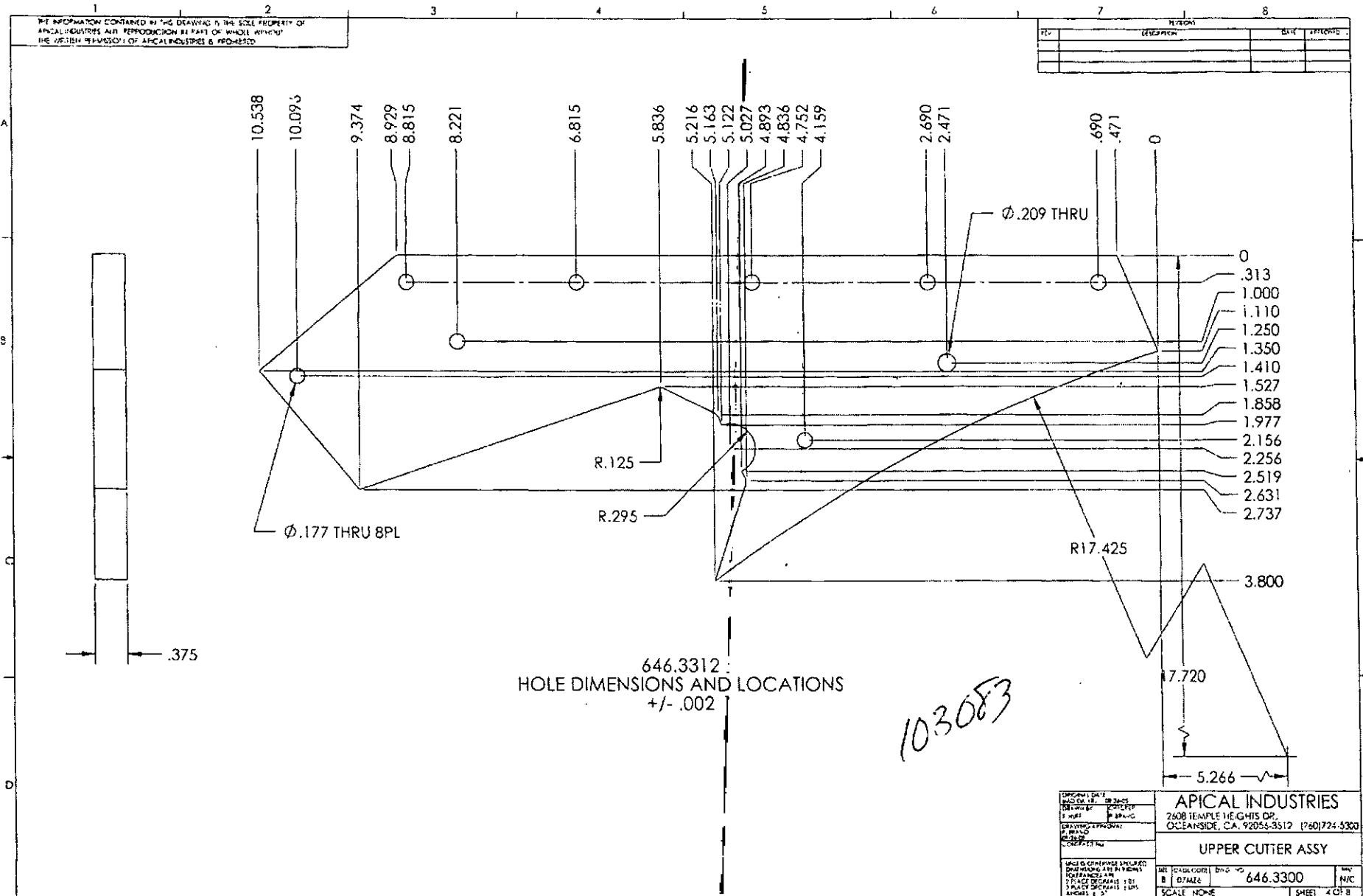
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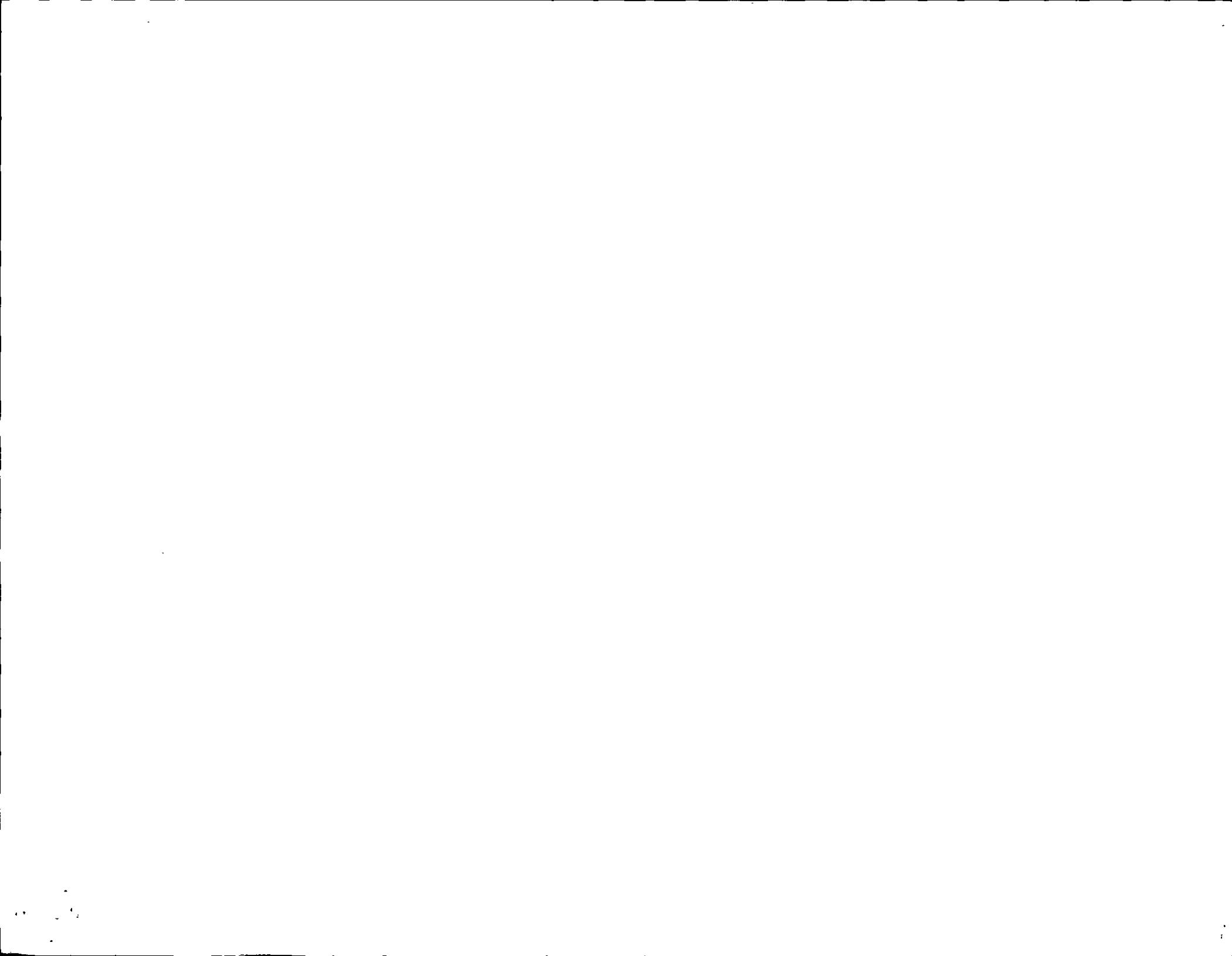


ORIGINAL DATE	10/10/01	REV. NO.	0
DRAWN BY	RE-C	DESIGNED BY	RE-C
SPANNING AMOUNT	100-120	APPROVED	
RE-REV'D BY		DATE	
APICAL INDUSTRIES			
2606 TEMPLE HEIGHTS DR.			
OCEANSIDE, CA. 92056-3512 (760)724-5300			
UPPER CUTTER ASSY			
REF. CAGE CODE	646.3300	REV.	N/C
646.3310	646.3311	DATE	10/10/01
SCALE	INCH	1	2 OF 6





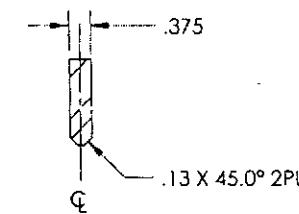
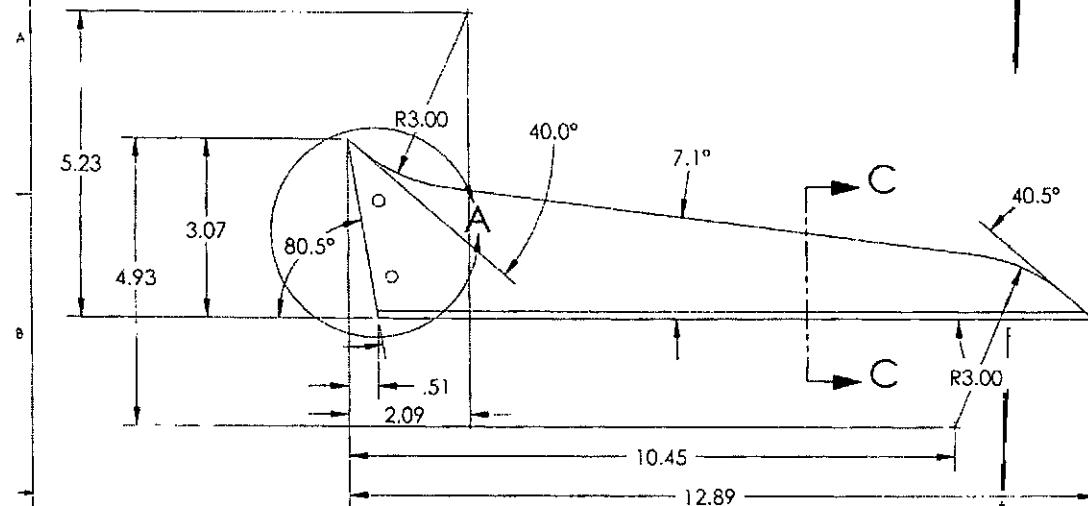




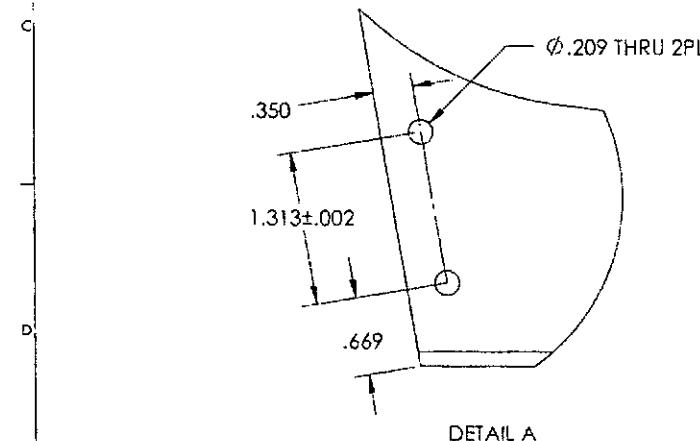
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ITEM	DESCRIPTION	QTY	APPROVED



SECTION C-C



103083

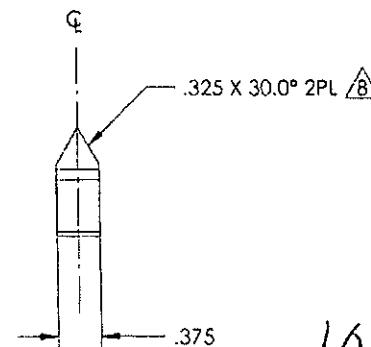
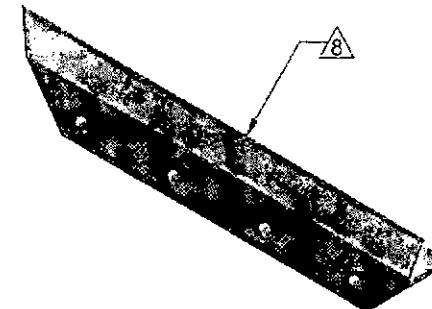
646.3313

ORGANIZATION	APICAL INDUSTRIES		
ADDRESS	2605 TEMPLE HEIGHTS DR. OCEANSIDE CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL	DRAFTED CHECKED APPROVED		
REVISIONS	10/10/04 10/10/04 10/10/04		
EXCEDED DRAWINGS	APICAL INDUSTRIES 2605 TEMPLE HEIGHTS DR. OCEANSIDE CA. 92056-3512 (760)724-5300		
DATE	10/10/04	DRAWING NO.	646.3300
SCALE	1:1	REV.	N/C
SPC	1	NUMBER	5 OF 8

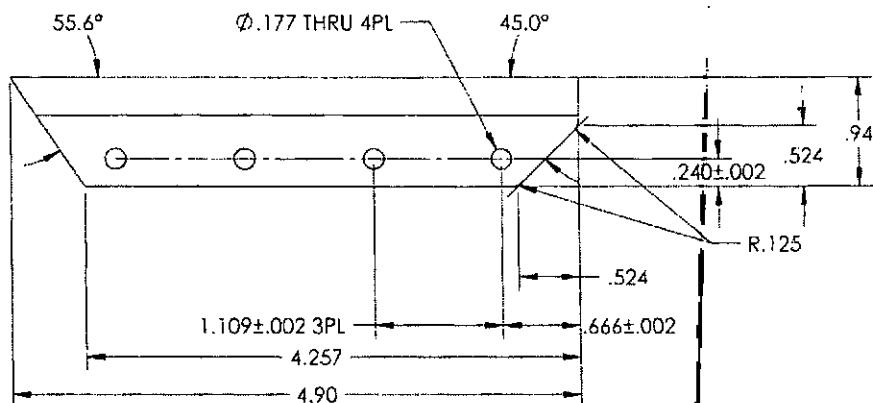


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REVIEWED		DEPARTMENT	REVIEWER	APPROVED



163087



646.3314

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KEY	DESCRIPTION	AVAILABILITY	
		DATE	AMOUNT

8

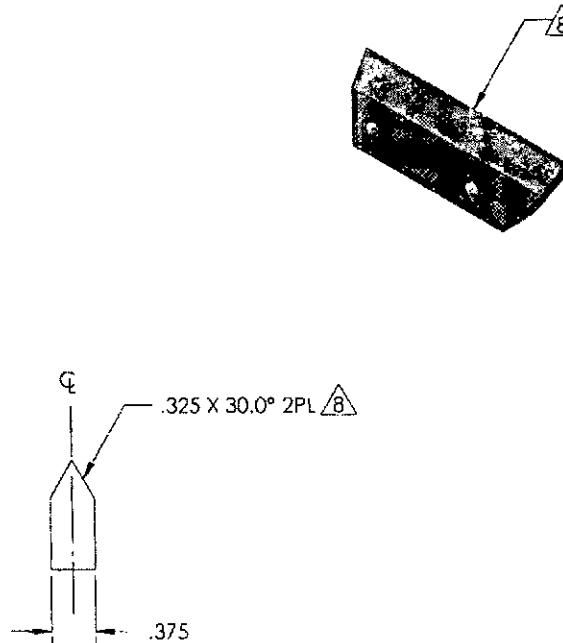
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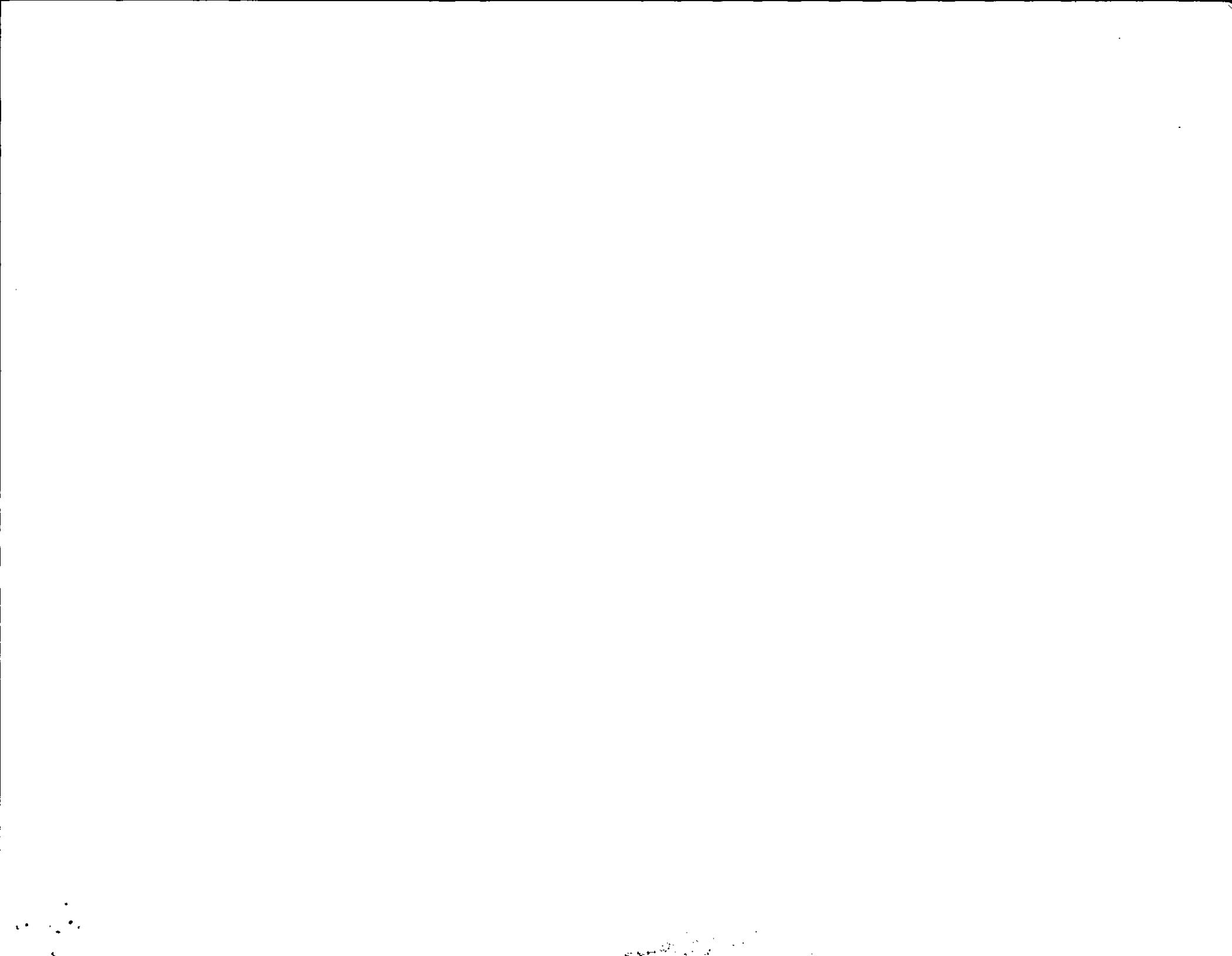
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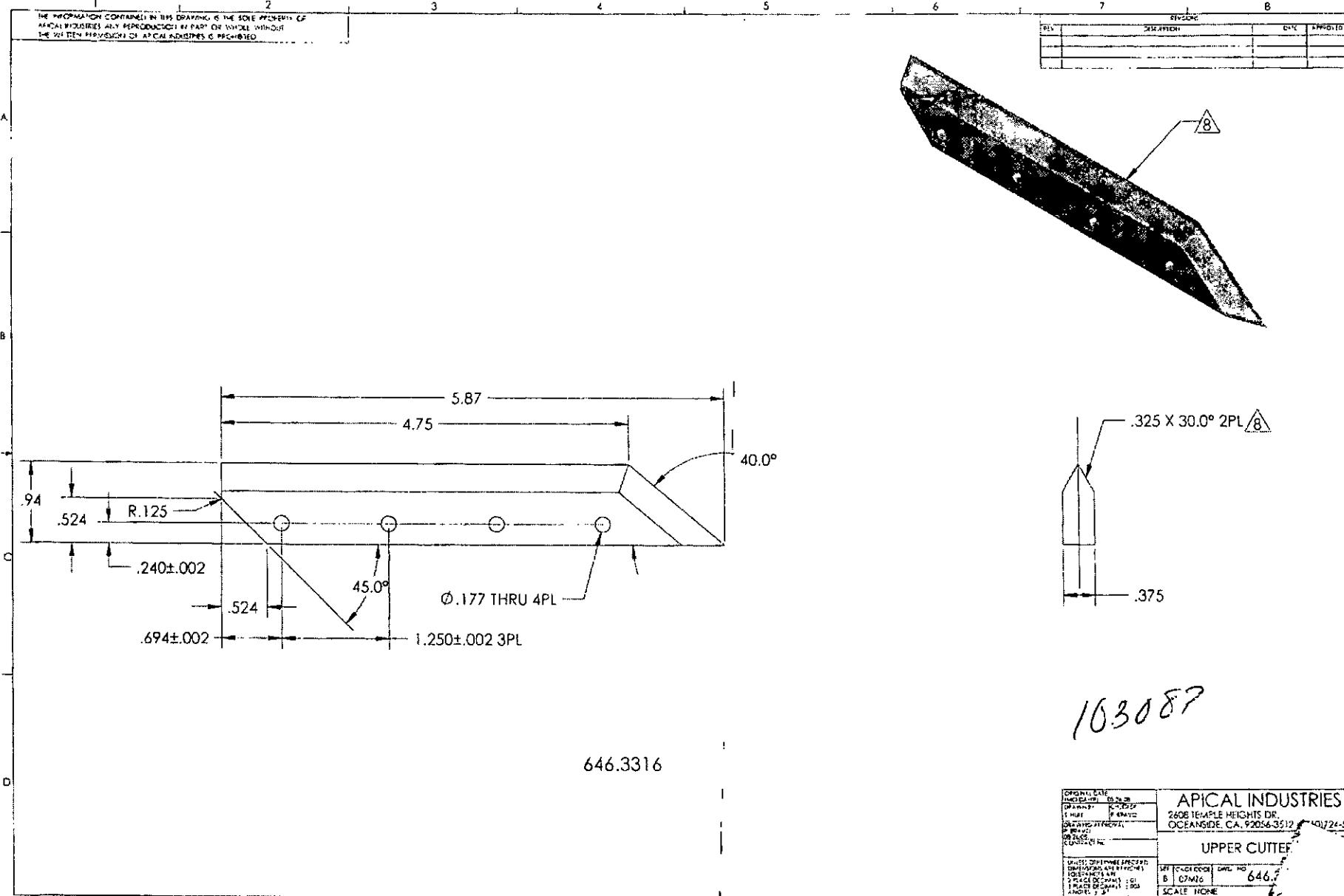
Technical drawing of a mechanical part. The part has a total height of .94. A horizontal slot is located at a depth of .290±.002 from the top. The distance from the bottom of this slot to the bottom of the part is .256±.002. The distance from the center of the slot to the center of a circular feature is .250±.002. The width of the part is 1.192±.002. A vertical dimension of 1.817 is shown between two horizontal lines. A horizontal dimension of 2.46 is shown between two vertical lines. A feature at the top is labeled $\phi .177$ THRU 2PL and has a lead angle of 55.6°. A vertical dimension of .55 is shown on the right side.

646.3315



103083







A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62536

Date: 01-Aug-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms	Ship Via
Quantity	Description
1 lot	Part: ASST 15 PCS 646.3311 16 PCS 646.3312 10 PCS 646.3313 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130473 PO: 20560 Line: _____
	Rev: _____ Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE <u>1/8/13</u> CERTIFIED SIGNATURE: <u>m</u> RECEIVER SIGNATURE: _____

